



Prime ABS Weather-X ML200 offers one of the highest aesthetics, gloss and depth of image in the industry, our Prime ABS Weather-X ML 200 may consist of 3-5 layers but is typically 3 consisting of clear acrylic, colored acrylic and ABS. Key properties are surface hardness, chemical resistance, weatherability, toughness and excellent formability.



## Prime ABS Weather-X ML200

Prime Weather-X ML200	High	Avg.
Impact Strength	*	
Low Temperature Impact Strength		*
Tensile Strength	*	
Flexural Modulus	*	
Heat Deflection Temperature	*	

Property	Test Method	Value	Unit
Specific Gravity	D-792	1.06	
Gloss, 60° Angle	D-523	85	%
Tensile @ Yield	D-638	5,900	psi
Flexural Strength	D-790	9,500	psi
Flexural Modulus	D-790	300,000	psi
Notched Izod	D-256	4.2	ft-lb/in
Rockwell Hardness	D-785	102	R Scale
HDT @ 264 psi	D-648	190	°F

### Applications:

Include; RV, automotive, transportation and marine industries.

### Finishing:

When drilling co-extruded sheet with an acrylic modified drill bit, be sure to exit from the acrylic side but when drilling with a standard bit, be sure to have the bit exit from the substrate side. For accuracy and safety, acrylic capped sheet should be clamped during drilling. For cutting/trimming Weather-X ML 200 sheet with CNC or air routers, a standard solid carbide fiberglass router – diamond-cut tool can be used. Routing parts in a CNC environment is best done with chip-breaker-type, solid carbide tools.

### Processing:

Surface Temp = 325-350°F

Mold Temp = 150-175°F

De-mold @ 170°F

Mold shrink is .004-.008 in/in. Oven heaters on gloss side should be somewhat lower than on the substrate side. The sheet must be fully saturated with heat before forming.

### Colors, Textures and Capabilities:

The surface is typically high gloss. Colors include Solids, Granite, Pearlescent, Swirl, Metallics, Soft White and Metamerism effects.

Please contact your Piedmont Plastics representative for more information on finishing, fabricating, or the thermoforming process.

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small enough to handle YOUR needs.*

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